Work Order ID 73108

Thursday, August 25, 2011 4:03:46 PM

Item ID: D205-778-011 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Comfort Seat, LH/RH

Start Date: 8/26/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 10/7/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** CL **Date:** 11/08/26 **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3800	B
DSI 9508	A
IIN D205-778	Rev B

100 0.00

DOCUMENT CONTROL

DC

Document Control

Memo 0.00

Photocopy bluefile & type labels per PPP D205-778-011 CHG 003

8/26/22

for ML 11-9-26

110 Pick Kit 0.00

Packaging

Packaging

Memo 0.00

11/9/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 73108

Thursday, August 25, 2011 4:03:46 PM

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Start Date: 8/26/2011 **Start Qty:** 1.00 **Cust Item ID:**

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
130		0.00							
Packaging	Packaging								
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D205-778-101 Location:_____ PPP Rev:_____								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11-09-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Thursday, August 25, 2011 4:03:43 PM

Work Order ID: 73108

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 8/26/2011 **Required Date:** 10/7/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:A 08-10-20 New Issue DD verified by:EC IPP Rev:B as per DSI 9508 DD 10.03-24 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD6L Washer		Purchased	No			110	Each	896.0000	16	16			
				Location			**Loc Qty**		**Loc Code**				
				ST347			896						
					5519		896			16			
BSP-42 Rivet		Purchased	No			110	Each	120.0000	8	8			
				Location			**Loc Qty**		**Loc Code**				
				ST284			120						
					114598		120			8			
D3752-1 Seat Frame		Manufactured	No			110	Each	1.0000	1	1 B73076			
				Location			**Loc Qty**		**Loc Code**				
				ST252A			1						
					67226		1						
D3755-041 Seat Cushion		Manufactured	No			110	Each	6.0000	1	1 11/9/26			
				Location			**Loc Qty**		**Loc Code**				
				ST252A			6						
					68934		2						
					71183		4						

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Thursday, August 25, 2011 4:03:43 PM

Work Order ID: 73108

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 8/26/2011 **Required Date:** 10/7/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3756-041	Manufactured	No		110	Each	6.0000	1	
Cushion								
		Location		**Loc Qty**		**Loc Code**		
		ST252A		6				
			68935	2				
			71184	4				
D3758-041	Manufactured	No		110	Each	9.0000	2	
Clamp								
		Location		**Loc Qty**		**Loc Code**		
		ST081		9				
			58262	9				2
D3777-041	Manufactured	No		110	Each	6.0000	2	2
Clamp								B73160
		Location		**Loc Qty**		**Loc Code**		
		ST081		6				
			46659	6				
D3800-3-200	Manufactured	No		110	f	128.9000	2	2.105263
Hook and Loop Strip (2" Hard)								11/9/2005
		Location		**Loc Qty**		**Loc Code**		2 feet
		ST083		128.9				
			56393	68.9				
			60044	60				

→ messo 8/10/22

1- Cut to lenght as per dwg (4x 6.00")

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Thursday, August 25, 2011 4:03:44 PM

Work Order ID: 73108

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 8/26/2011 **Required Date:** 10/7/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN525-10R8		Purchased	No	110	Each	69.0000	8	8	
Screw									

Location	Loc Qty	Loc Code
ST325	69	
114494	69	

AN970-3		Purchased	No	110	Each	78.0000	8	8	
Washers									

Location	Loc Qty	Loc Code
ST349	78	
115158	2	
117395	76	

AN960JD10	NAS1149D0363J	Purchased	No	110	Each	0.0000	8	8	M1180728
Washer									
MS21042L3		Purchased	No	100	Each	1,783.000	8	8	11/9/2011
Nut									

Location	Loc Qty	Loc Code
ST300	1783	
117441	150	
117601	400	
117885	233	
118451	1000	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-778-011 Comfort Seat Kit, LH / RH	13.0 lb 5.9 kg	±22.0 in ±0.56 m	±286 in-lb ±3.3 m-kg	47.0 in 1.19 m	611 in-lb 7.0 m-kg

5.0 PARTS LIST

Qty -011	Part Number	Description
X	**D205-778-011**	**COMFORT SEAT KIT (FITS LH & RH)**
1	D3752-1	SEAT FRAME
1	D3755-041	CUSHION
1	D3756-041	CUSHION
2	D3758-041	CLAMP ASSEMBLY
*2	D3758-1	CLAMP
*2	D2182B028	RUBBER CUSHION
2	D3777-041	CLAMP ASSEMBLY
*2	D3777-1	CLAMP
*2	D2182B013	RUBBER CUSHION
4	D3800-3-200-060	HOOK STRIP
8	AN525-10R8	SCREW
8	AN970-3	WASHER
8	AN960JD10	WASHER
8	MS21042L3	NUT (OR MS21042-3)

* REFERENCE ONLY. PARTS ARE INCLUDED IN ASSEMBLY ABOVE.

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-778 REV. B
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-778 REV. ~~1~~ 8
REF TCCA STC: SH08-37
REF FAA STC: SR02704NY
REF EASA STC: EASA.IM.R.S.01518

REFERENCE ONLY

PURPOSE:
To provide instructions to allow the hook strip (ie. velcro) on the D3752-1 Seat Frame to be fastened with rivets.

CHANGE:
D205-778-011 Comfort Seat Kits at CHG 002 have rivets and washers that may be installed to fully secure the D3800-3-200-060 Hook Strip to the D3752-1 Seat Frame. The parts list of Installation Instructions IIN-D205-778 and Instructions for Continued Airworthiness ICA-D205-778 is amended as shown below. Installation of the rivets is optional.

PARTS LIST

QTY -011	Part Number	Description
X	**D205-778-011**	**Comfort Seat Kit**
8	BSP-42	Rivet (Add)
16	NAS1149DN616J	Washer (or AN960JD6L) (Add)

INSTALLATION INSTRUCTIONS

Install the BSP-42 rivets as detailed below, see Figure 1 of this service instruction as reference:

1) Ensure location of D3800-3-200-060 Hook Strip lines up with loop strip on seat cushions.
2) Drill D3752-1 Seat Frame using 9/64" (Ø0.141) drill in appropriate locations: ensure rivet location will not interfere (contact) with the OEM metal seat frame. Deburr hole.
3) Install each BSP-42 rivet with qty(2) NAS1149DN616J washers (one on either side of the plastic seat frame). It is acceptable to substitute longer/shorter BSP rivets or thicker NAS1149DN632J washers to ensure proper fit.

UPGRADE KIT

For D205-778-011 Comfort Seat Kits at CHG 001, the DSI-9508-011 Rivet Kit is available from Dart:

QTY -011	Part Number	Description
X	**DSI-9508-011**	**Rivet Kit**
8	BSP-42	Rivet
16	NAS1149DN616J	Washer (or AN960JD6L)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: D. SHEPHERD (DE # 02)
DATE: 10.03.02
CERT. NO.: SH08-37
ISSUE NO.: 1

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	CP	10.03.02

DESIGN	GP	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	GP		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9508	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIVET KIT	NTS
DATE	10.03.02		

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